



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship May 24
Order 5782
003509
3545

648.4703

Job Sheet 176680



Part No: 648.4703

Job Qty: 1 ea

Part Name: C10 Overhaul Kit



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG O&OPM-C10 Rev 4 IPP Rev A 18.03.14 New issue DP Verify DD

Ship Via:

5079215

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/24/18	0.00	0.00	Start Up Stores/Pkg-1		18-06-08
110	Small Fab	1 pcs		5/24/18	0.00	1.00	Small Fab-6		18-06-08
120	QC	1 pcs		5/24/18	0.00	0.00	QC4		38 DAS
125	DC	1 pcs		5/24/18	0.00	0.00	DC		28 JRB
130	Packaging	1 pcs		5/24/18	0.00	0.00	Packaging3-1		28 JRB
140	QC21-FG	1 Ea		5/24/18	0.00	0.00	QC21		21 18-06-15

Part Op 110 - Pick bag and tag

Descriptions: 125 - Supply owner's & overhaul procedures manual

130 - Identify and pack for shipping as per PPP 647.7303

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1/4 20-3/8	Set Screw	2 Ea (2 ea)	90-Start up Operation	5048557
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	90-Start up Operation	5058750
188-SHCS-1032-3/4	Bolt	8 Ea (8 ea)	90-Start up Operation	5042363
600.1309-A	Label	1 Ea (1 ea)	90-Start up Operation	5064516
600.1347	C10 Warning Label	1 (1 ea)	90-Start up Operation	5029487
AN4-23A	Bolt	2 Ea (2 ea)	90-Start up Operation	F123434-40
AN6-31A	Bolt	6 Ea (6 ea)	90-Start up Operation	5048403
AN960-416	Flat Washer Dia 1/4" NAS1149F0463P	3 Ea (3 ea)	90-Start up Operation	5056461-1
AN960-416L	Washer NAS1149F0432P	2 (2 ea)	90-Start up Operation	5050055
AN960-616L	5/8" OD, THIN FLAT WASHER see NAS1149F0632P	12 Ea (12 ea)	90-Start up Operation	5048297-1
C10-10-2	Actuator Pin	1 pcs (1 ea)	90-Start up Operation	5029190
C10-10-3	Actuator Bushing	2 pcs (2 ea)	90-Start up Operation	5068885
C10-21-4	Lock Washer	8 Ea (8 ea)	90-Start up Operation	5038404
C10-22	Lock Bumper - one missing	3 Ea (3 ea)	90-Start up Operation	5063972/5078626
C10-23-1	Keeper Spacer	1 Ea (1 ea)	90-Start up Operation	5029200
C10-23-2	Keeper Spring	1 pcs (1 ea)	90-Start up Operation	5060601
C10-23-3	Keeper Bushing	2 Ea (2 ea)	90-Start up Operation	5029201
C10-3	Load Beam Bumper	1 Ea (1 ea)	90-Start up Operation	5076247
C10-4-10	Spring Anchor Spring Pin	2 pcs (2 ea)	90-Start up Operation	5029208
C10-4-6	Lock Spring	1 pcs (1 ea)	90-Start up Operation	5029215
C10-4-7	Spring Retaining Pin	1 pcs (1 ea)	90-Start up Operation	5029216
C10-4-8	Lock Bushing	2 Ea (2 ea)	90-Start up Operation	5060579

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Desc _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspect ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machine ☐ Cross ☐ Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Rec/Store/Packaging ☐ Other ☐ Supplier ☐ MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
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 CANADA
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Container No: S079215
Part: 648.4703
Job No: 176680
Serial No/Batch: S079215
Revision: 4
Inspector: _____
Exp Date: 06/08/2018
Date: 06/08/18

Root Cause	
Environment	☐ No Re-verifica
Design	☐ Operator
Doc/Data	☐ Offset/Setup
Equip/Tooling	☐ Supplier
Handling/Pre	☐ Training
Material	☐ Use for Testing
Internal Transport	☐ Poor Information
Tribal Knowledge	☐ Rushing
LOA	☐ Product Improvement
Substation	☐ Process Improvement
Past Expiry Date	☐ Manufacturing Process
Misidentified	☐ Past Due

☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Wave/Twist in Tube
☐ Marks/Chatter
☐ OTHER :

☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Mislabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

C10-4-9 <i>PR</i>	Upper Roller DU Bearing -	1 pcs (1 ea)	90-Start up Operation	5009218 5071378
C10-7 <i>PR</i>	Locating Pin -	3 pcs (3 ea)	90-Start up Operation	5029220
C10-8	Trunnion Bushing <i>missing -</i>	2 pcs (2 ea)	90-Start up Operation	5068715
C10-9-2 ✓	Latch Bearing Torrington -	1 Ea (1 ea)	90-Start up Operation	5068889
C10-9-4	Latch Shaft Bearing <i>missing -</i>	2 pcs (2 ea)	90-Start up Operation	5077378
C10-9-6 ✓	Latch Return Spring ✓	2 Ea (2 ea)	90-Start up Operation	5046045
C2-14-2 ✓	Label Rivets -	2 Ea (2 ea)	90-Start up Operation	5057170
C3-12-6 ✓	Lock Roller Pin Circlip -	2 Ea (2 ea)	90-Start up Operation	5072853
C45-12-6 <i>PR</i> ✓	Retaining Ring -	2 Ea (2 ea)	90-Start up Operation	5029303
C45-8-4 <i>P</i> ✓	Solenoid Cover Gasket -	1 Ea (1 ea)	90-Start up Operation	5029336
MS21044N6 ✓	Nut, Self-Lock .375-24, UNJF-3B ✓	6 Ea (6 ea)	90-Start up Operation	5065332
MS21083N4 ✓	Nut -	2 Ea (2 ea)	90-Start up Operation	5062621
MS27039-4-08 ✓	Screw -	1 Ea (1 ea)	90-Start up Operation	5039330

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1/4 20-3/8	2	46	0
	188-FPSS-1032-1/4	2	104	0
	188-SHCS-1032-3/4	8	284	0
	600.1309-A	1	0	0
	600.1347	1	0	0
	AN4-23A	2	606	0
	AN6-31A	6	38	0
	~ AN960-416	3	0	0
	~ AN960-416L	2	0	0
	AN960-616L	12	0	0
	C10-10-2	1	0	0
	C10-10-3	2	0	0
	C10-21-4	8	76	0
	C10-22	3	17	0
	C10-23-1	1	0	0
	C10-23-2	1	60	0
	C10-23-3	2	0	0
	C10-3	1	0	0
	C10-4-10	2	0	0
	C10-4-6	1	0	0
	C10-4-7	1	0	0
	C10-4-8	2	21	0
	C10-4-9	1	0	0
	C10-7	3	0	0
	C10-8	2	0	0
	C10-9-2	1	9	0
	C10-9-4	2	0	0
	C10-9-6	2	17	0
	C2-14-2	2	264	0
	C3-12-6	2	16	0
	C45-12-6	2	48	0
	C45-8-4	1	14	0
	MS21044N6	6	72	0
	MS21083N4	2	280	0
	MS27039-4-08	1	86	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					